Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D4016-1
Job Sheet 194798

Part No: D4016-1 **Job Qty:** 40 pcs
Part Name: Hinge Half, Base
Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 5/8/19 **Job Tracking No:**
Due Date: ~~6/26/19~~ June 16 **Created By:** Marie Lajeunesse
Type: Stock **Description:**
Note: DWG REV B SHEET 1 IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD IPP Rev:B as per dwg REV.A DD 10.02.22 verified by:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Standard Run Hrs	Workcenter / Supplier	Lead Time	Sign-off
100	**Bandsaw - 1**	40 pcs		6/26/19	0.00	2.60	Bandsaw - 1	DAS 32 DAS 9-89	19/06/10
110	**HAAS 4 Axis - B4B**	40 pcs		6/26/19	0.03	17.17	HAAS - 1 - B4B	52	19/06/10
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	**QC 8**	40 pcs		6/26/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		JL 19-6-12
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
160	**Packaging 3-1 - Stock - B4B**	40 pcs		6/26/19	0.00	0.00	Packaging 3 - 1 - B4B		

DART AEROSPACE
Container No: S188922
Part: D4016–1
Job No: 194798
Serial No/Batch: S188922
Revision: B
Inspector:
Exp Date:
Instructions: Various STC's
Date: 06/10/19

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					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc WA004-F
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
170 **QC 21 - SA**	40 pcs	6/26/19	0.00	0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-88 JUN 13 2019
					QC 21 - SA - 53	

Part Op Descriptions:
100 - CUT BLANK 1.00" LONG
110 - (HAAS CNC Vertical Machine), MACHINE AS PER FOLIO FA869 AND DWG
130 - (QC8- Inspect parts - second check
160 - (Identify as per dwg & Stock Location:_____)
170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304B1.000X1.000	304 Bar 1.00 X 1.00	3.2000 ft (.08 ea)	100-Bandsaw - 1	S151 404

MAT used 3.500

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304B1.000X1.000	3	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Base	0.875Inches ± 0.010	0.885 0.865	0.872	
2	Hinge Half, Base	0.250Inches ± 0.030	0.280 0.220	0.240	
3	Hinge Half, Base	0.380Inches + 0.030 - 0.000	0.410 0.380	0.390	
4	Hinge Half, Base	0.030Inches ± 0.030	0.060 0.000	Radius 0.015	
5	Hinge Half, Base	0.130Inches ± 0.030	0.160 0.100	0.123	
6	Hinge Half, Base	0.880Inches ± 0.030	0.910 0.850	.880	
7	Hinge Half, Base	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter .256	
8	Hinge Half, Base	0.380Inches ± 0.030	0.410 0.350	Radius 0.377	
9	Hinge Half, Base	0.500Inches ± 0.030	0.530 0.470	.500	
10	Hinge Half, Base	0.750Inches ± 0.030	0.780 0.720	.754	

Plex 5/8/19 1:53 PM Dart.lajeunesse.marie

DAS 52 9-89 19/06/09

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

DART AEROSPACE

NCR No.

Route update only ☐

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Water Jet ☐
Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐
Quality ☐

Date :	Sequence #:	QTY Affected :	MRB (QSI042)

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor
		QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Presservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Positioned Wrong
☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance
☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Drawing
☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Finish
☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing
☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Misread
☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up

Other/Details: